

Work Order ID 56580

March 1, 2010 2:47:34 PM

Page 1

Item ID: DSK078

Accept

Setup Start

Revision ID:

Stop

Item Name: D2893-1 TURNING DETAIL

Start Date: 3/01/10 Start Qty: 10.00

Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 03/01/10 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



Doosan

MORI SEIKI CNC LATHE LARGE

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

SL
SA 10/03/28

10 0

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

SL
SA 10/03/28

10 0

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

mm
10/03/29

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56580

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Page 2

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 3/01/10 Start Qty: 10.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Identify and Stock in Kanban Location: DSK078

MNF
10/03/29

10

8

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/30

10-3-29
10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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[illegible][illegible]**Required Date:** 3/08/10

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	0.0000	10.0000			
												
Round Billet, 17-4												

B56585 x 12 2/10

B56585 x 102 21/10/03/30

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56580
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.710	2.710	2.710	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.075	3.074	3.074	3.074	3.074
D	0.718	0.738		.725	.725	.725	.725	.725
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.944	2.944	2.944	2.944
G	2.166	2.186		2.174	2.174	2.174	2.174	2.174
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.119	.119	.118	.119
L								
M								
N								
O								
P								

Measured by:	<i>SA / MME</i>	Date:	10/05/27 / 10/01/29
Audited by:		Date:	
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

[Handwritten Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56580
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
Lathe Section								
A	2.707	2.712		2.710	2.710	2.709	2.710	2.710
B	4.946	4.966		4.960	4.960	4.960	4.960	4.960
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.725	.725	.725	.725	.725
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.944	2.944	2.944	2.944	2.944
G	2.166	2.186		2.174	2.174	2.174	2.174	2.174
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.119	.119	.119	.119	.119
L								
M								
N								
O								
P								

Measured by: SA / SA	Date: 10/03/28
Audited by: MW / 10/03/29	Date:
Prototype Approval:	Date:

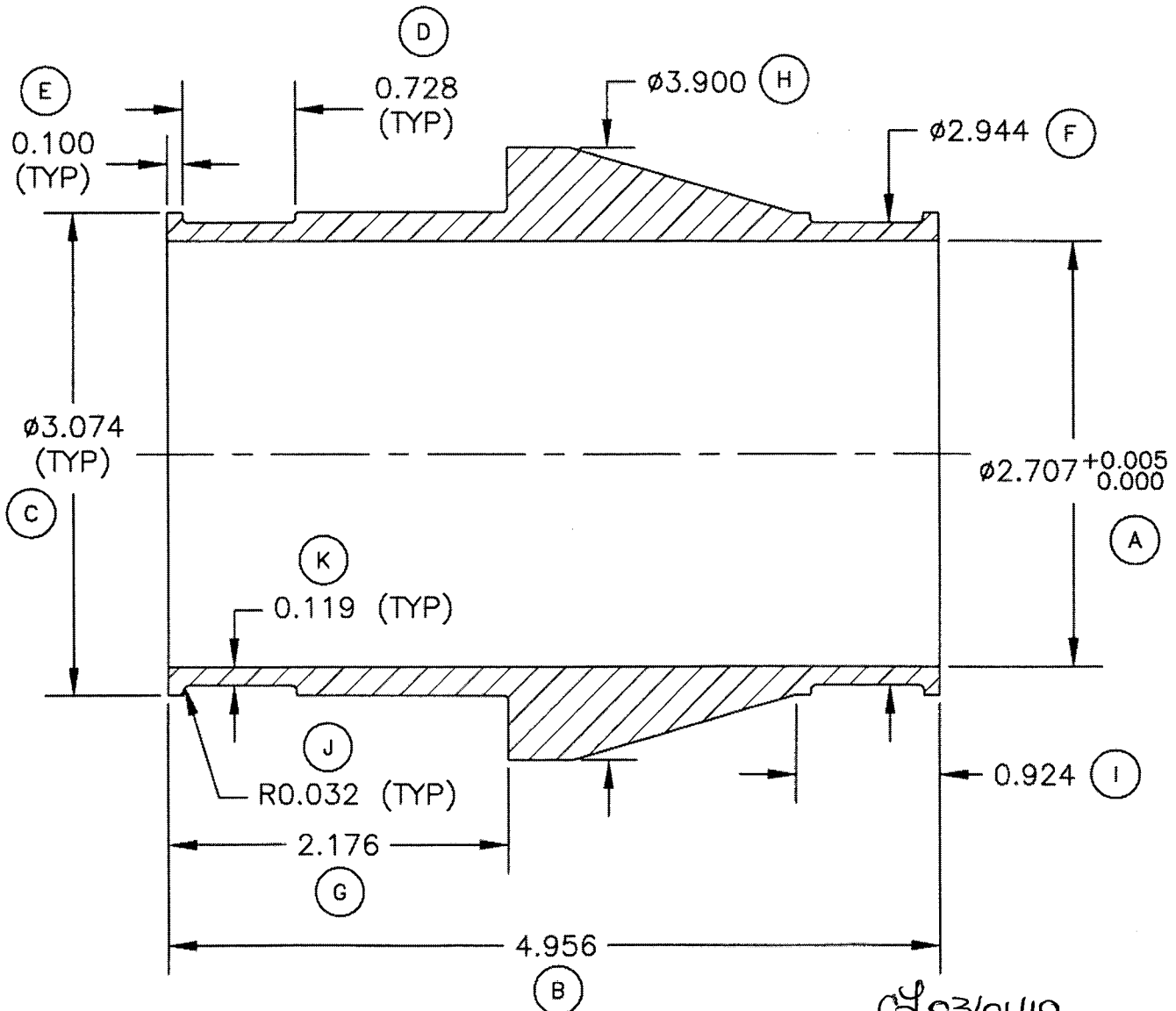
Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

2.946

D2893-1 TURNING DETAIL03/01/10
W/D: 56580

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